

### **Ask Questions – position yourself by understanding your audience – 15 min max**

- How many shifts are running ?
- Where are the bottlenecks in your plants - Corrugator or Converting ?
- Is the corrugator keeping up with converters ?
- Any starch pump or line blockages ?
- How are they currently cleaning up ?
- Duration and frequency of clean ups ?
- Any issues with bearings ? Are they getting wet ?
- Issues with airbags ?
- Average square feet of board achieved per minute ?
- Deckle width ?
- Top speed per minute – 820ft/ 985ft ?
- Do you often get warp ? If so, what do you do ?
- *Would 30 minutes extra board production a day be worth while ?*

### **Importance of a clean applicator roll daily**

1. Starch dries in the cells during the process of applying starch through a day of operation. Cells are filling up and drying at different rates. This leads to uneven application which can lead to warping or delamination
2. Starch dries behind and around the scrapping blade during the process which leads to blade damage and harder start up. This can also allow solid pieces to fall into the starch and in the board, weakening or even damaging the board
3. BHS and Fosber, state you should clean the corrugator every day and a big deep clean once a week  
THEY ARE THE EXPERTS !
4. Cleaning the applicator roll with cold solutions can damage the roll and equipment because it is hot

### **Importance of a weekly deep clean of the corrugator**

1. Dried starch gets caught up in many areas and has to be removed to prevent starch pump blockage, weaker and slower board production
2. Dried starch on air bags can reduce the life of the bag as it can wear the rubber and slow operation.  
Airbag replacement causes loss of production time
3. Dried starch on the blade can cause slow start up, damage the blade and cause long term damage of the applicator roll
4. Trays have dried starch that can break away mixing into the starch damaging board, blocking starch pumps and damaging starch pumps
5. Clean applicator rolls apply starch correctly

**All of this delivers flatter, stronger board,  
and MORE BOARD**